

Date: Thursday, 4/20/2006 9:57:59 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
<b>Job Number</b> : 23804	
<b>Estimate Number</b> : 10007	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D205596101
<b>This Issue</b> : 4/20/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D205-596-101 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 11/9/2005 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : A
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> :	<b>Due Date</b> : 4/14/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev G Removed Bending 05-10-25 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy D205-594 bluefile &amp; type labels per PPP D205-596-101 CHG001

DA 05.07.19 ①

2.0	D2889	FWD Crosstube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

FWD Crosstube

Pick:

Qty Part number Description Batch

1 D2889 Fwd Crosstube

B22533 DP06-4-26

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

2- Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

DP06-4-20

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Conformity check and sign off by engineering.

DP06-05-08

5.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

DP06-5-8

2-Deburr &amp; Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one

Pm'06-05-9(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/20/2006 9:57:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 23804

Part Number: D205596101

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



*PC 06-05-26 (1)*



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06-05-31 (1)*

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Prime inside and outside with Immron per QSI 005 4.2

*PC 06-08-22  
MM BB 23 (1)*

9.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

*06-08-24 (1)*

10.0 D2856600 Abrasion Strip



Comment: Qty.: 0.7090 f(s)/Unit Total : 0.7090 f(s)

Abrasion Strip

Pick:

Qty Part number Description Batch

2 D2856-600-851 Abrasion Strip *B24328*

*2T 06-09-05*

11.0 D28931 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support

Pick:

Qty Part number Description Batch

2 D2893-1 Support *B27425*

*2T 06-09-05*

12.0 MS2192024 Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-24 Clamp *B15298*

*/M101334<sup>2</sup>/M100213<sup>1</sup> 2T 06-09-05*

*4*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date: 06/09/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 4/20/2006 9:57:59 AM  
User: Linda Lacelle

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

**Job Number:** 23804

**Part Number:** D205596101

Job Number:



**Seq. #:**      **Machine Or Operation:**      **Description :**

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



**Comment:** LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg  
D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

25 06 09 05

14.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

DP 6-9-5

15.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location: \_\_\_\_\_

REV E 26/9/6

16.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Inspection Level 21

26/09/07

Job Completion



U 2009.06

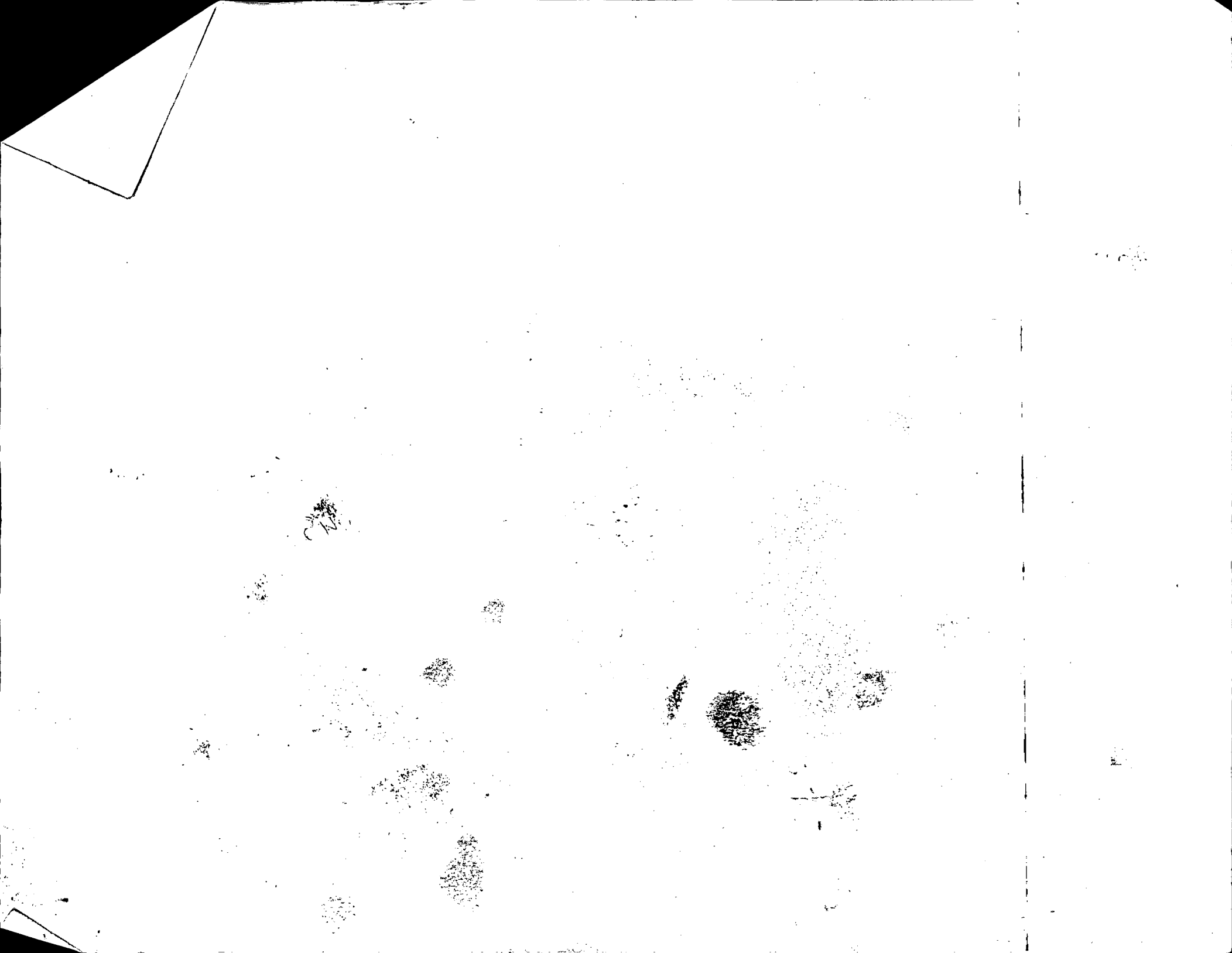
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

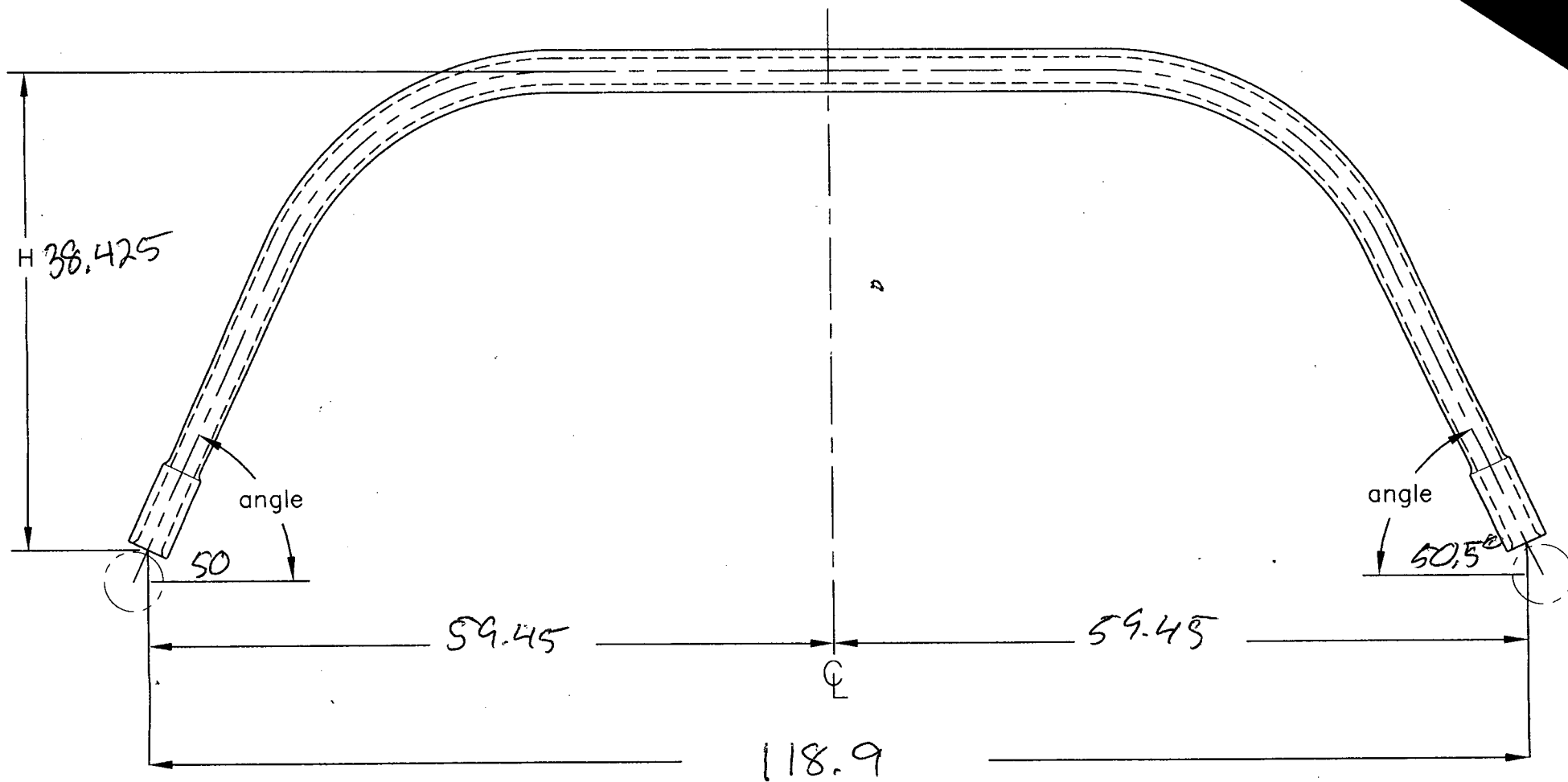
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DATE: 06.05.04

DESCRIPTION: D208-596-101

BATCH NO: 23804

DRAWING: D205-596-101 Rev A

H: ~~38.425~~ 38.3"

1/2 SPAN: 59.6"

TOTAL SPAN: 119.2"

ANGLE: 50"

*[Signature]*  
06.05.04



Date: Friday, 12/01/2007 3:03:24 PM  
User: Linda Lacelle

# **Process Sheet**

Customer : CC-DAR01 Dart Aerospace Ltd.

Job Number : 30252

Estimate Number : 10804

P.O. Number : N/A

This Issue : 12/01/2007

Prsht Rev. : NC

First Issue : N/A

Previous Run : 30251

S.O. No. : N/A

Type : OVERHEAD

Drawing Name

: D205-594 - ECN 904

Part Number : Z\_CUSTOM

Drawing Number : UPDATE PAPERWORK

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 19/01/2007

Qty:

1 Um:

Each

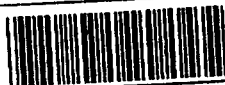
Written By :

Checked & Approved By :

Comment :

Additional Product

Job Number:



Description :

Seq. #:

Machine Or Operation:

PACKAGING RESOURCE #1

1.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK  
EASA STC EASA.IM.R.S.01198

D205-596-101

D205-596-103

D205-596-105

D205-596-107

D205-596-109

B 23804 1X 21

B 24946, B 24078, B 26841 = 3

B 28663 1=

FINAL INSPECTION/W/O RELEASE

2.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



U 27-01-15